shp Wed. 26/03

Rev E DAS 16 9-89 14/03/26

PRELIMINARY ISSUE

Work Order ID 115294

March-24-14 12:55:54 PM

115294

Item ID: D4541-8
Revision ID:
Item Name: Bracket

D4541-8
D115294

Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4541	**Revision Nbr** E								
100		0.00							
100						10	0		JM14-03-25
Waterjet	**Memo**	0.00							
FLOW CNC Waterjet	1- Cut as per dwg(D4541-7f) Prog rev: PE2 Dwg rev: PE2 2- Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						10	0		JM14-03-25
QC	**Memo**	0.00							
Quality Control									

DAS 27 9-89

DAS 10 9-89

Work Order ID 115294

March-24-14 12:55:54 PM

115294

Item ID: D4541-8
Revision ID:
Item Name: Bracket
Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00			DAS 27 9-89 14/3/25	10			
					Inspect as per Dwg PED				
130 *130* Small Fab Small Fab	**Memo** Bend tabs as per dwg	0.00 0.00			DAS 30 9-89	10			14/03/25
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O **Memo**	0.00 0.00				(10)	14-03-26		DAS 9 9-89

Work Order ID 115294

March-24-14 12:55:54 PM

115294

Item ID: D4541-8
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Item Name: Bracket
Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100*

Setup Start *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____
Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
144	Chemical Conversion Coat per QSI005 4.1	0.00							
144						10	MG	14-3-26	
HandFinish	**Memo**	0.00							
Hand Finishing									
146	QC7-Inspect Chemical Conversion Coat	0.00							
146						10			
QC	**Memo**	0.00							
Quality Control						Inspect as per DW, PEQ			
150	Identify as per dwg & Stock Location: S1527A	0.00							
150						10			
Packaging	**Memo**	0.00							
Packaging									

DAS 27 9-89 — 14/3/26

DAS 28 9-89 — MAR 26 2014

Item ID: D4541-8
Revision ID:
Item Name: Bracket
Start Date: 3/24/14 **Start Qty:** 10.00 *10*
Required Date: 3/25/14 **Req'd Qty:** 10.00 *10*
Reference:

Accept *N900040100* **Setup Start** *NS1*
Stop *NS2*

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____
QC: _____ **Date:** _____

Tooling: _____ **Date:** _____
SPC (Y/N): _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MLJ 14-03-26

MF 14-3-2

POSITIVE RECALL
EFFECTIVE 4/23/24 AUTH
RELEASED DAS 16 9-89 DATE 4/03/26

Release DWG or Rev E DAS 27 9-89 14/3/26

Picklist Print

March-24-14 12:55:54 PM

Work Order ID: 115294 *115294*

Parent Item: D4541-8 *D4541-8*

Parent Item Name: Bracket

Start Date: 3/24/14 **Required Date:** 3/25/14

Start Qty: 10.00 **Required Qty:** 10.00

Comments: IPP REV:A 13.02.12 new issue DD verf:JLM
13.04.23 as per dwg revD DD verf:JLM
IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032		Purchased	No			100	sf	379.2832	0.258	3			
M6061T6S.032									**				
6061-T6 Sheet 0.032"													

JM 14-03-25

Location	Loc Qty	Loc Code	
MAT021	379.28317		
123483	8.57		
m125822	17		
m127272	119.43317		
m128054	234.28		128054

DART AEROSPACE LTD		Work Order:	11594
Description:	Bracket	Part Number:	D4541-7
Inspection Dwg:	D4541 Rev: PE2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098"	+0.004 -0.001	0.099"	–		V	JM05
Ø0.257"	+0.006 -0.002	0.259"	–		V	
0.344"	+/-0.010"	0.346"	–		V	
0.688"	"	0.690"	–		V	
0.320"	"	0.320"	–		V	
1.00"	+/-0.030"	1.007"	–		V	
0.80"	"	0.812"	–		V	
1.66"	"	1.667"	–		V	
2.5"	+/-0.000"	2.5"	–		V	
16.2"	"	16.2"	–		T	JM07
0.032"	+/-0.05"	0.031"	–		V	

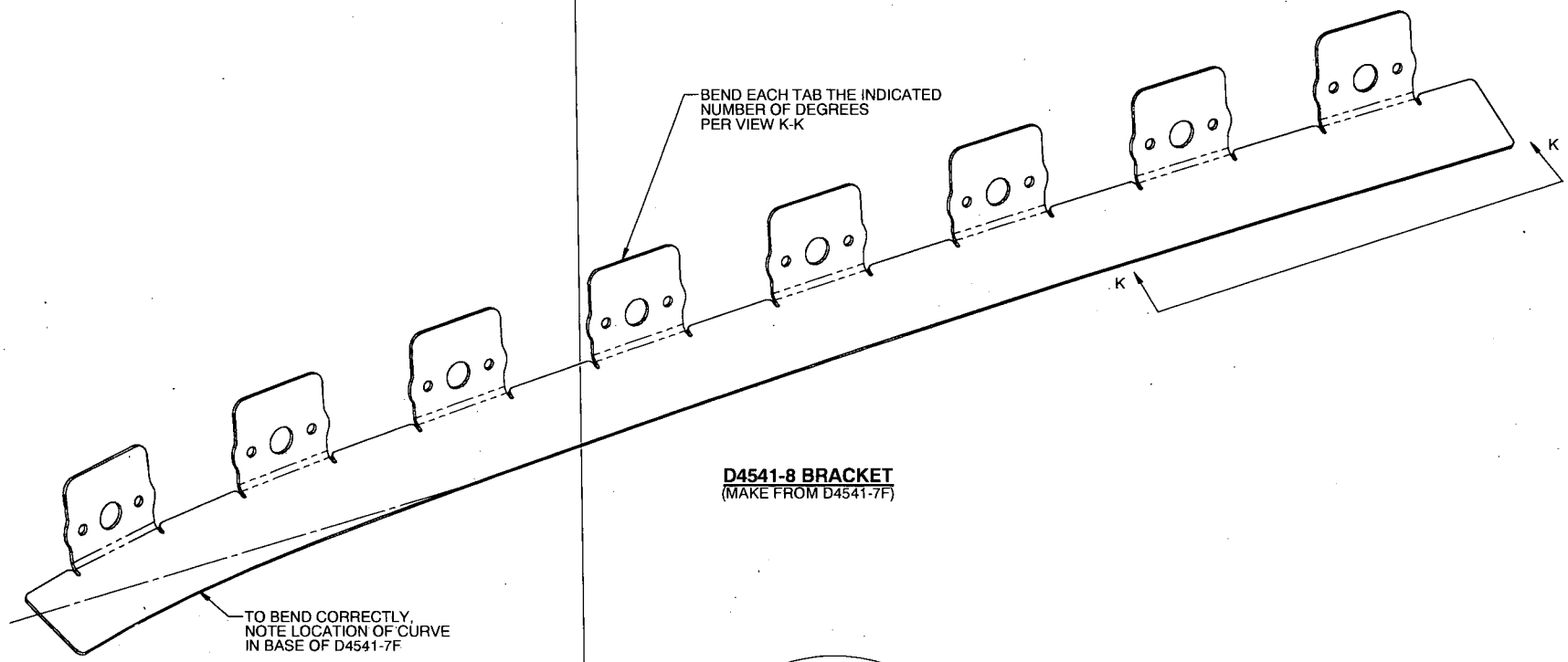
Measured by:	JM
Date:	14-03-25

Audited by:	DAS 27 9/89
Date:	4/3/25

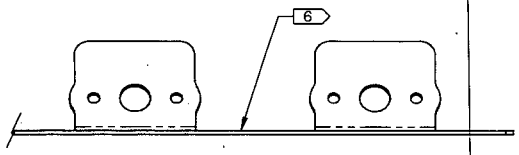
Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

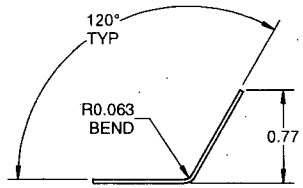
10.04.15



D4541-8 BRACKET
(MAKE FROM D4541-7F)



VIEW K-K
BEND DETAIL
NOT TO SCALE



PE2

0.76 TO BEND TANGENT, REF
(0.80 TO BEND CENTER)

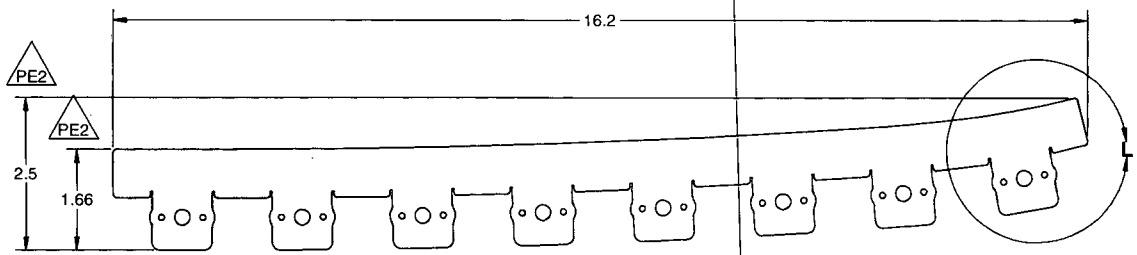
PRELIMINARY E2
14.03.07 (AJS)

NOTES:
1) MATERIAL: MAKE FROM D4541-7F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.06 lbs

No 115294

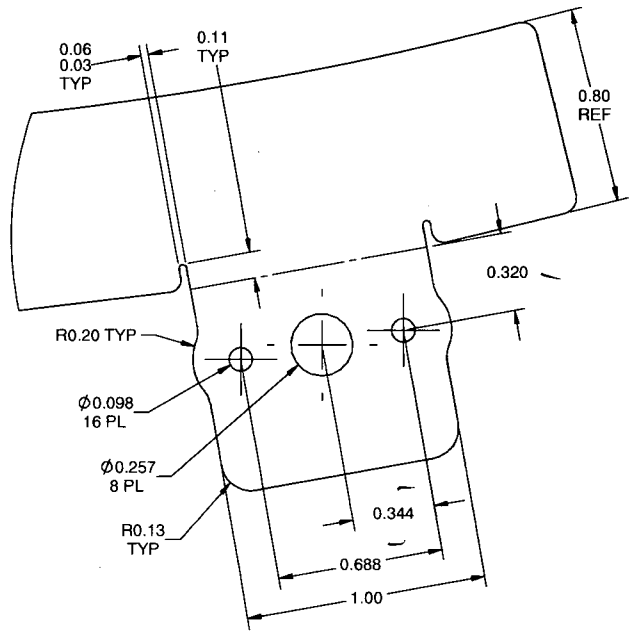
DESIGN	CP	**DART AEROSPACE LTD**
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	JB	DRAWING NO. D4541 — REV. PE2
MFG. APPR.		SHEET 12 OF 13
APPROVED	MO	TITLE BRACKET — SCALE NTS
DE APPR.		
DATE	14.03.07	

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D4541-7F FLAT PATTERN

GRAIN DIRECTION



DETAIL L
TYP TAB DETAIL
SCALE 4X

NOTES:
1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.06 lbs
8) PROFILE PER DRAWING FILE "D4541-7F-REVE.DXF"

PRELIMINARY E2
14.03.07 (AJS)

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE2
MFG. APPR.		D4541	SHEET 13 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07		

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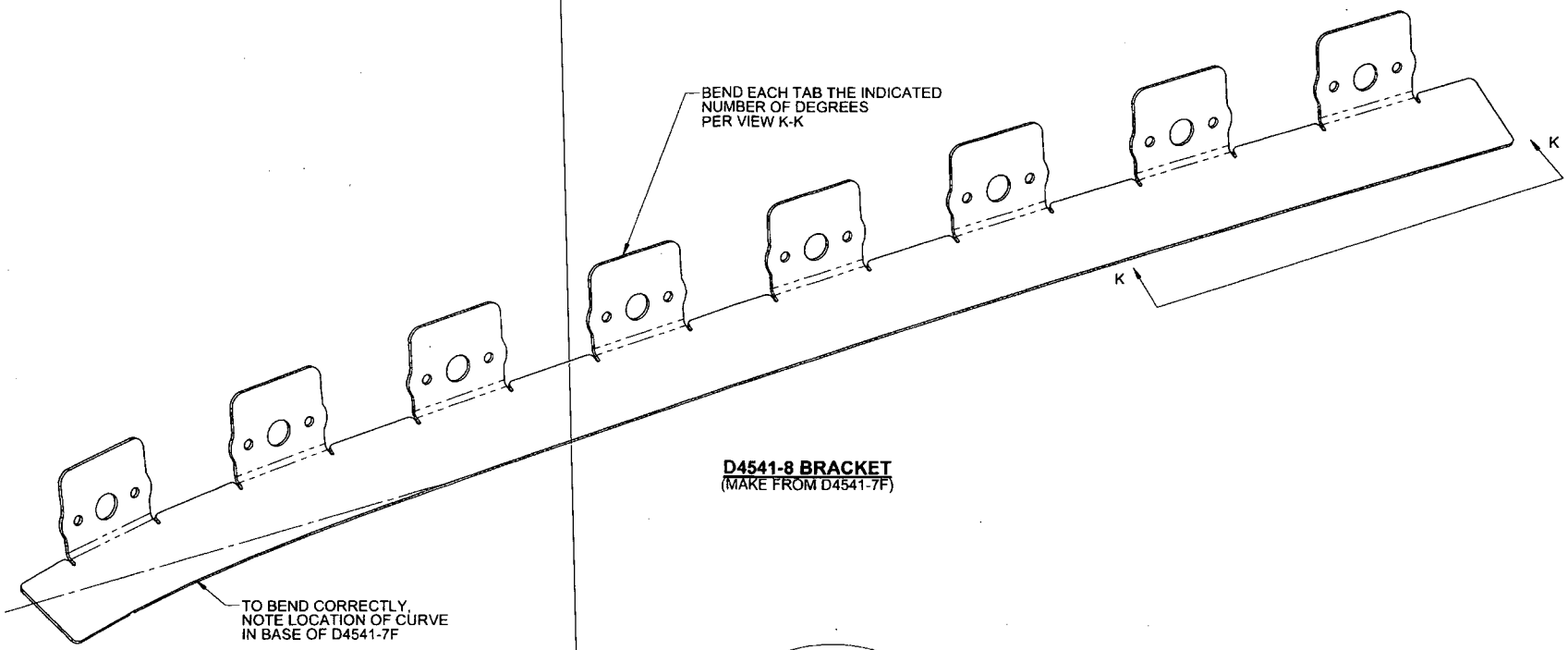
DART AEROSPACE LTD

Description:	Bracket	Work Order:	115 864
Inspection Drawing:	D4541	Rev:	PE2
Part Number:	D4541-8		

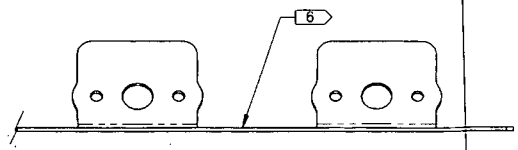
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.77	+/- .030	.775	✓		V	Sht-11
.78	+/- .020	.77	✓		V	Sht-11
120°	+/- 1/2°	120°	✓		Protector	Sht-7

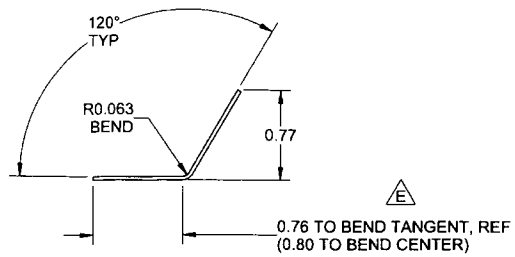
Measured by: DAS 30 9-89	Checked By: DAS 36 9-89	QC inspector: DAS 9 9-89	Engineering Approval (*if necessa*
Date 14/03/25	Date 14/03/25	Date 14-03-26	Date



D4541-8 BRACKET
(MAKE FROM D4541-7F)



VIEW K-K
BEND DETAIL
NOT TO SCALE

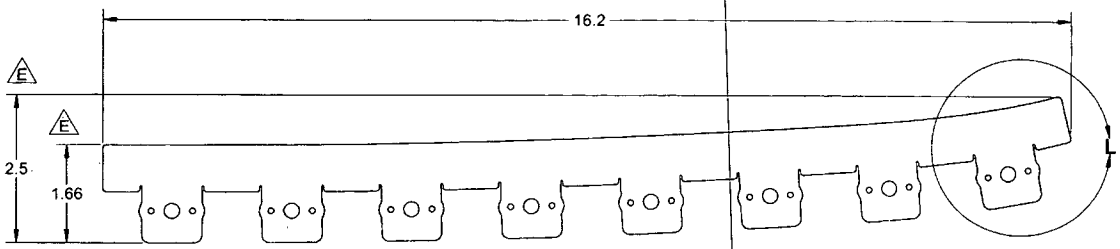


RELEASED
2014-03-26

NOTES:
1) MATERIAL: MAKE FROM D4541-7F
2) FINISH:CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: DART P/N & B/N PER DART QSI 044 6.1
7) WEIGHT: 0.06 lbs

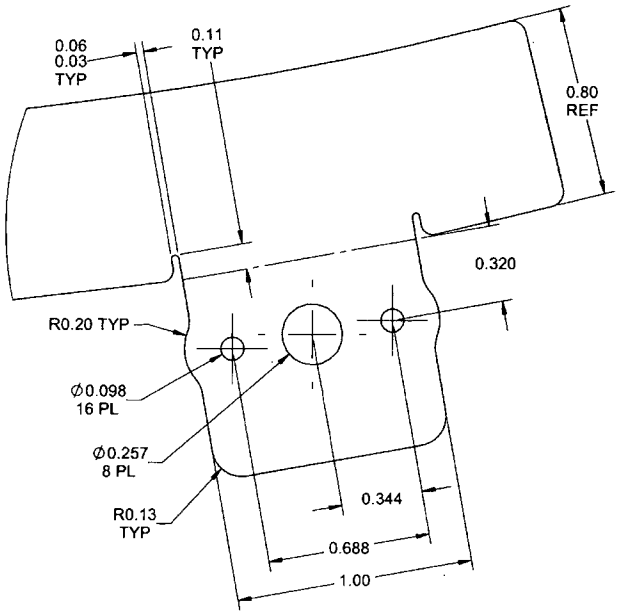
DESIGN	CP	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D4541 REV. E
MFG. APPR.		SHEET 12 OF 13
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 14.03.07		

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D4541-7F FLAT PATTERN

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DETAIL L
TYP TAB DETAIL
SCALE 4X

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REF DART SPEC. M6061T6S.032
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.06 lbs
8) PROFILE PER DRAWING FILE "D4541-7F-REVE.DXF"

DESIGN	CP	**DART AEROSPACE LTD**	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4541	SHEET 13 OF 13
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	14.03.07		

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